



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB500N9505-1M
Job Sheet 166494



001205

Part No: RB500N9505-1M

Job Qty: 1 pcs

Part Name: Notar Drive Shaft Coupling Socket (Modified)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/13/17

Job Tracking No:

Due Date: 10/27/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

DAS
10
9-89
Burg Rev 3

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/27/17	0.00	0.00	Start up container	NCC
110	Small Fab	1 pcs	10/27/17	0.00	0.00	Small Fab	DAS NCC
120	QC	1 pcs	10/27/17	0.00	0.00	QC5	38
130	Packaging	1 pcs	10/27/17	0.00	0.00	Packaging3	GT 9-88
140	QC	1 pcs	10/27/17	0.00	0.00	QC21	

Job Allocations

DAS
21
FEB 27 2018

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	329-820 5006154	1	0	0	0
	RB500N9505-1M-1	1	0	0	0
	RB500N9505-1M-3	1	0	0	0
	91257R501	1			

5040928 DAS 1149F083LP S+262 F18057

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:15%;">☐</td> <td style="width:15%;">Cross tube</td><td style="width:15%;">☐</td> <td style="width:15%;">Water Jet</td><td style="width:15%;">☐</td> <td style="width:15%;">Engineering</td><td style="width:15%;">☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Other</td><td>☐</td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Finishing	☐	Rec/Store/Packaging	☐	Supplier	☐	Other	☐																																																																								
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Date : _____		Step #: _____		MRB (QSI042) Approval																																																																																																			
Description Work Order Completed By _____ Date: 02/27/18 DART AEROSPACE Container No: S045864 Part: RB500N9505 - 1M Job No: 166494 Serial No/Batch: S045864 Revision: RB500N9505 - 1M Inspector: _____ DART Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL: 1 613 832-5200 Email: sales@dartaero.com www.dartaero.com																																																																																																							
Root Cause <table style="width:100%;"> <tr> <td style="width:15%;">Environment</td><td style="width:15%;">☐</td> <td style="width:15%;">No Re-verification</td><td style="width:15%;">☐</td> <td style="width:15%;">Pressure</td><td style="width:15%;">☐</td> <td style="width:15%;">Positioned Wrong</td><td style="width:15%;">☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Centre Not Concentric</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td></td><td></td> <td></td><td></td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> <td></td><td></td> <td></td><td></td> </tr> </table>								Environment	☐	No Re-verification	☐	Pressure	☐	Positioned Wrong	☐	Design	☐	Operator	☐	Bending	☐	Outside Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐					Misidentified	☐	Past Due	☐				
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OTHER : _____																																																																																																							

Work Order ID 166494

Monday, September 25, 2017 9:25:56 AM

166494

Page 1

Item ID: RB500N9505-1M

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Notar Drive Shaft Coupling Socket (Modified)

Start Date: 10/27/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/27/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: DAS Date: SEP 25 2017 Tooling: _____ Date: _____
21
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
RB500N9505-1M	3

110

0.00

110

Small Fab

Memo

0.00

Small Fab

-Assemble as per DWG. Sheet 1

-Loctite M _____

Exp; _____

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
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Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Monday, September 25, 2017 9:25:56 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 10/27/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/27/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/
Run Hours**Tool ID****Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
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Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

Monday, September 25, 2017 9:26:00 AM

Parent Item: RB500N9505-1M

Parent Item Name: Notar Drive Shaft Coupling Socket (Modified)

Start Date: 10/27/2017

Required Date: 10/27/2017

Start Qty: 1.00

Required Qty: 1.00

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

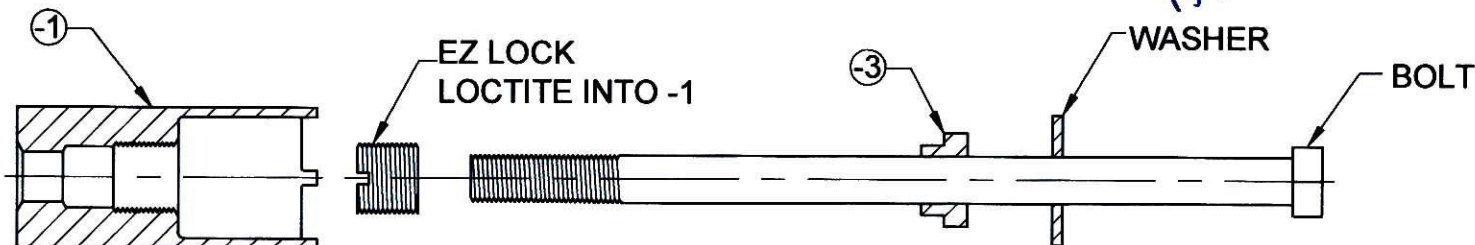
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
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Design	☐	Operator	☐	Bending	☐	Set-up	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	ADDED ASSEMBLY DRAWING.	8/31/06	WP
2	INSTALLED NEW DRAWING FORMAT, REDUCED FROM 3 PAGES, AND ADDED LOCTITE NOTE.	9/23/08	WP
3	SEPERATED PARTS ONTO INDIVIDUAL PAGES. -1 CHD DIM WAS Ø.532 THRU C-SINK Ø.78 X 120". BROACH .50, IS Ø.484 THRU C-SINK Ø.78 X 120". BROACH .50, INDEXING NOT IMPORTANT. -3 CORRECTED GUIDE WAS SAME AS RB500N9506-3 IS SAME AS RB500N9506-1M-3.	6/27/13	BIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 126454 MJS
1309-25



MCM# 91257A501

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	SOCKET	41L40 RND. BAR	Ø1-1/2 x 3-3/8	2
			-3	1	GUIDE	STRESS PROOF	Ø1 x 5/8	3
		B/O		1	EZ LOCK	STEEL	O.D. 3/4-10 UNC, I.D. 1/2-20 UNF x .565 REID #329-820	1
		B/O		1	BOLT; CAD YELLOW	GRADE 8	HHB-0500-20-10-GR8	1
		B/O		1	FLAT WASHER; CAD YELLOW	GRADE 8	FW-0500-GR8	1

RED BARN MACHINE	
TITLE DRIVE SHAFT COUPLER SOCKET; ASSEMBLY	
DWG NO. RB500N9505-1M	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-18-00
SHEET 1 of 3	

MCM# 98032A347

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Michael Lee

From: Michael Lee
Sent: Monday, February 5, 2018 6:25 PM
To: Jean-Luc Menard; Chantal Lavoie
Cc: Robert Aboud
Subject: RE: RB500N9505-1M ORDER 792 due feb 9th
Attachments: RB500N9505-1M rev 3.pdf

Hello,

Sorry for the slow response.

Please use the following hardware from McMaster Carr:

- Bolt 91257A501 (1/2-20 x 10")
- Washer NAS1149F0832P (in stock)

Cheers,

NO DEBATE REQUIRED

Mike

From: Jean-Luc Menard
Sent: Monday, February 5, 2018 8:22 AM
To: Chantal Lavoie <clavoie@dartaero.com>; Michael Lee <mlee1@dartaero.com>
Cc: Robert Aboud <raboud@dartaero.com>
Subject: RE: RB500N9505-1M ORDER 792 due feb 9th

Bolt is 1/2-20
Washer is for 1/2" bolt.
JL

From: Chantal Lavoie
Sent: Monday, February 05, 2018 8:01 AM
To: Michael Lee <mlee1@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>
Cc: Robert Aboud <raboud@dartaero.com>
Subject: FW: RB500N9505-1M ORDER 792 due feb 9th

Good morning Mike,
Would need the size of the bolt and washer, see dwg below.
Thanks
Chantal

From: Chantal Lavoie
Sent: Monday, February 05, 2018 7:34 AM
To: 'Eric Bourgon (eric@mainindustrialsales.com)' <eric@mainindustrialsales.com>
Subject: FW: RB500N9505-1M ORDER 792 due feb 9th